

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-002813**Date Inspected:** 05-Jun-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** C. M. Chen**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector Tim McClendon arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai, China to periodically monitor welding and Quality Control (QC) functions. While on site the QA Inspector observed and/or discovered the following.

OBG Assembly Segment 3AE- The Caltrans QA Inspector observed that ZPMC has fit-up the FL1 floor beam on the south side and also the FL2 to the bottom plate. ZPMC is currently in process of fitting up and tack welding the longitudinal diaphragm to the D6 bottom plate.

OBG Assembly Segment 4AE- The Caltrans QA Inspector observed that ZPMC is in process of fitting up the FL2 floor beam.

OBG Assembly Segment 3BW- The Caltrans QA Inspector observed that ZPMC is in process of FCAW the 3F fillet welds that join the Floor beam FL2-1 to the FL-1 on both sides of the assembly.

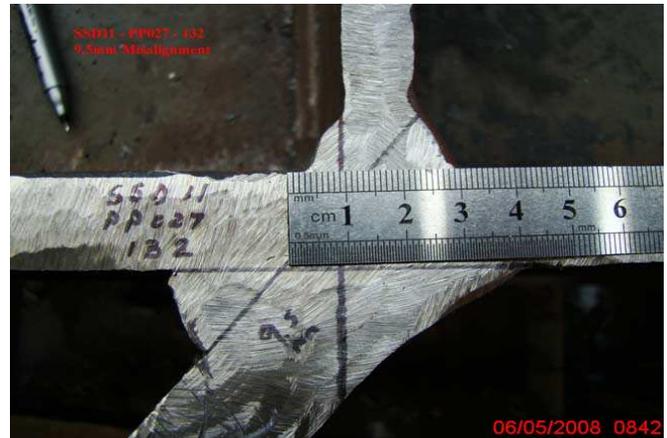
The Caltrans QA Inspector performed dimensional verification on the floor beam diagonal support bolt connection plates to the FL2-1 flange plate with measured misalignment of the mating stiffeners that exceed the allowable tolerance of the Special Provisions, "Shop Welding", "General Provisions", Section G2. A 1.4mm + tolerance has been calculated for these components. The following components were recorded and measured to contain the following misalignment 4BW SSD11 PP027, weld number 132 measures 9.5mm misalignment, weld number 006 measures 4mm misalignment. An incident report will be written on this issue.

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# WELDING INSPECTION REPORT

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## Summary of Conversations:

No relevant conversations spoken on this date.

## Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Pat Lowry, (858) 344-2712, who represents the Office of Structural Materials for your project.

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**Inspected By:** McClendon, Timothy

Quality Assurance Inspector

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**Reviewed By:** Cuellar, Robert

QA Reviewer